

Work Order ID 99576

Thursday, April 11, 2013 1:19:13 PM

99576

Ship today

Page 1

Item ID: D2986-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rubber Spacer

Stop

NS2

Start Date: 4/11/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/11/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: UMK

Date: 13-4-11

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2986	Rev B

100 0.00

100 FLOW WATER JET

Waterjet Memo 0.00

FLOW CNC Waterjet 1-Cut as per Dwg D2986

~~400-125~~ Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

6 0 Jm13-4-11

110 0.00

110 QC2- Inspect parts off machine FAI/FAIB

QC Memo 0.00

Quality Control ***template DT3187-1T1***

6 0 Jm13-4-11

120 0.00

120 QC8- Inspect parts - second check

QC Memo 0.00

Quality Control

SMF
134 11

6 _____

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Item ID:	D2986-1	Accept	*N900040100*	Setup	Start	*NS1*		
Revision ID:						Stop	*NS2*	
Item Name:	Rubber Spacer							
Start Date:	4/11/2013	Start Qty:	4.00	*4*	Cust Item ID:			
Required Date:	4/11/2013	Req'd Qty:	4.00	*4*	Customer:			
Reference:						Run	Start	*NR1*
Approvals:	Process Plan:	Date:	Tooling:	Date:		Stop	*NR2*	
	QC:	Date:	SPC (Y/N):	Date:				

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging	Identify as per dwg & Stock Location: Memo	0.00				6x			S 13-4-11
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							MJ 13-4-11 MF 13-4-11

Picklist Print

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Work Order ID: 99576

Parent Item: D2986-1

Parent Item Name: Rubber Spacer

Start Date: 4/11/2013

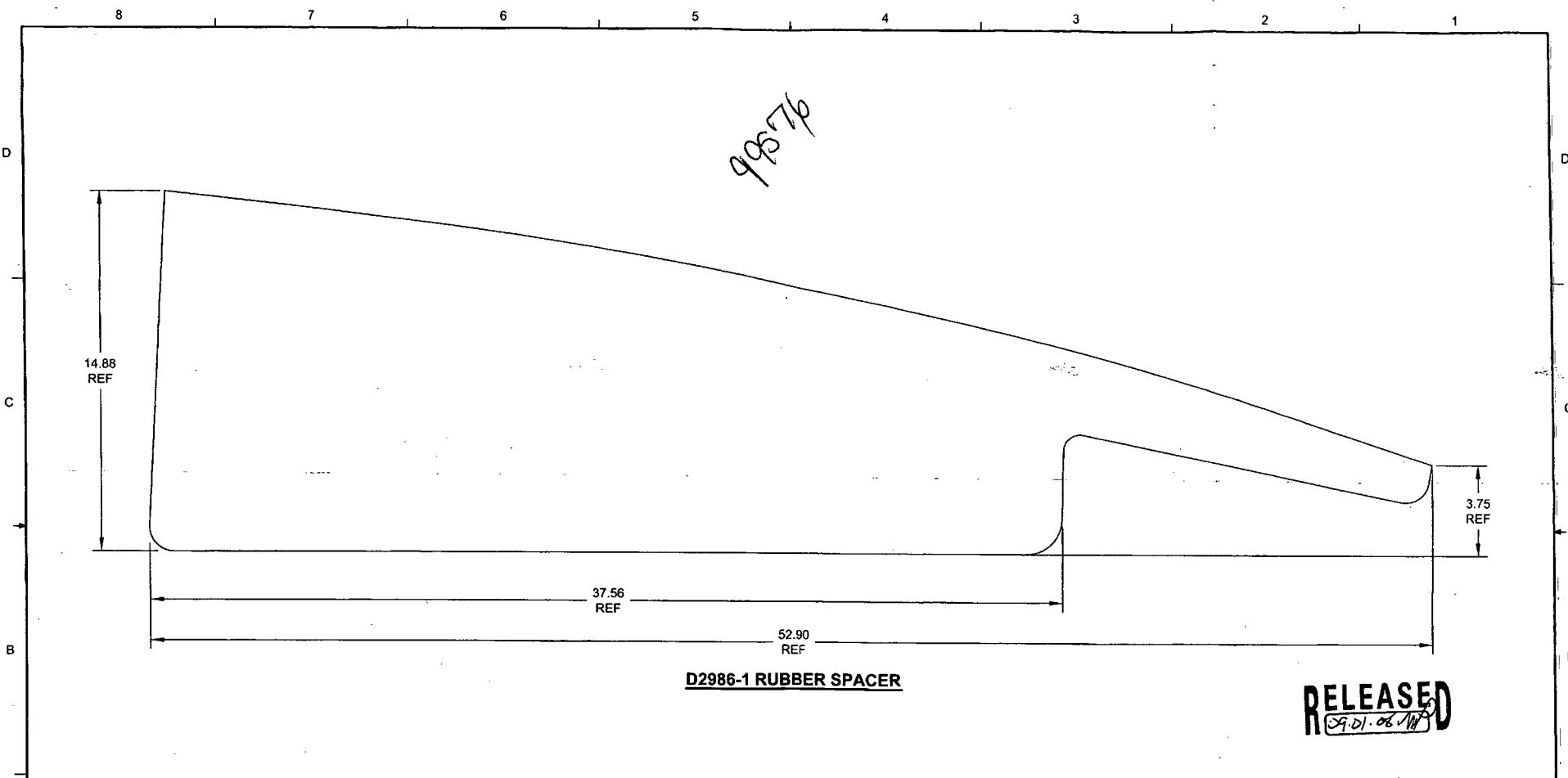
Required Date: 4/11/2013

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:B 09-01-20 rev.B as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125		Purchased	No			100	sf	223.1800	5.466	23.014737			
4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"													
Jm.3-4-11													
<u>Location</u>				<u>Loc Qty</u>			<u>Loc Code</u>						



NOTES:

- 1) MATERIAL: BLACK NEOPRENE/EPDM/SBR BLEND SHEET (ROLL), 0.125 THICK, PER ASTM D 1056 GRADE 2A1 OR SAE J-18 GRADE 2A1 (REF. DART SPEC. M-4111N-S-125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.3 lbs
- 8) TOOLING: CUT PER TEMPLATE DT3187-1T1

B	REDRAWN TO CURRENT STANDARDS; TRANSFERRED TO B-SIZE FORMAT; ADDED PART DWG DETAIL; REVISED NOTE 1; REMOVED SUPPLIER AND SPEC DWG NOTES. REASON: ECN#08-589.	MB	08.12.18
A	NEW ISSUE	DS	00.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D2986	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		RUBBER SPACER	NTS
DATE	08.12.18	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED TO THE EXPRESS COMPANY THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____		DISPOSITION			AGAINST DEPARTMENT/PROCESS								
Part No. _____		Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Machining <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____		Work Order Update <input type="checkbox"/>			Thermoforming <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube					General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

DART AEROSPACE LTD	Work Order:	99576
Description: Rubber Spacer	Part Number:	D2986-1
Inspection Dwg: D2986	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	<u>JPM</u>	Audited by:	<u>SMB</u>	Prototype Approval:	N/A
Date:	(34-11)	Date:	134/11	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.06.11	New Issue	KJ	M

NCR: Yes / No

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework	Scrap	Use-as-is	Skid-tube	Crosstube	Water Jet	Engineering		
NCR No. _____	Work Order Update			Machining	Small Fab	Prod. Eng. Coor.	Quality		
				Thermoforming	Finishing	Rec/Store/Packaging	Other		
				Large Fab	Composite	Supplier			

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

FAULT CATEGORY

Landing Gear	General														
	<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced											
	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure											
	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld											
	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled											
	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Part Moved												
	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Positioned Wrong												
	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Power Loss/Surge												
	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes													
	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing													
	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish													
	<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio													